

Date: Wednesday, 12/20/2006 11:58:59 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: JET
Job Number	: 29990		
Estimate Number	: 10583		
P.O. Number	: N/A		
This Issue	: 12/20/2006 S.O. No. : U/A	Part Number	: D2003077
Prsht Rev.	: NC	Drawing Number	: UNDER REVIEW CB 66.12.20
First Issue	: N/A	Project Number	: N/A
Previous Run	: 29928A	Drawing Revision	: A
Written By	: <u> </u>	Material	: N/A
Checked & Approved By	: <u> </u> 06 12 20	Due Date	: 1/15/2007 Qty: 11 Um: Each
Comment	: Est: A 04.05.17 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T0375W035	6061-T6 Tube .375 x.035W	
		Comment: Qty.: 1.0625 f(s)/Unit Total : 11.6875 f(s) 6061-T6 Tube .375 x.035W Material: 6061-T6 tubing 0.375OD x 0.035" wall (M6061T6T0.375W.035) Batch: <u>m17931</u> MF 8.5(f) MF 07-01-08	
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Cut (2) D2003-077 blanks per (1) DSI 9051 Kit 2- Cut blanks: 6.250" long as per template D2003-077 3- Form, drill & as per template D2003-077 Identify for D2003-077	mF. 07-01-09 (P/C)
3.0	516IN200	Set Screw	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s) Set Screw Pick: Qty Part Number Description Batch 1 2 5/16"-18 NC -.200 Set Screw <u>m19473</u> MF. 07-01-09	
4.0	AN8186D	Nut	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 22.0000 Each(s) Nut Pick: Qty Part Number Description Batch 1 2 AN818-6D Nut <u>m17651</u> MF. 07-01-09	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07-01-08	2.0	Remove flares. And put at step 6.0 at assembly, After putting on the sleeve. Perm-change <i>Z</i>	MF.	07-01-09	11	<i>Z</i> 07-01-08 QSI042	<i>Z</i> 07-01-08
07-01-09	6.0	Applied locktite 262 thread locker. #B m102963 on each screw. ADD TO step 6.0 perm-change <i>Z</i>	MF.	07-01-09	11	<i>Z</i> 07-01-15 QSI042	<i>Z</i> 07-01-15

Part No: B2903-077 PAR #: _____ Fault Category: Pro/Engineering (cardinal) NCR: Yes No DQA: Date: 07/01/13
 QA: N/C Closed: _____ Date:

NCR: <u>29990</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-08	2.0	W/O instructions were wrong. Flare was made before the hardware was picked, and the sleeve was installed. <i>Z</i> QSI042.	<i>Z</i>	grind off the flare as necessary to install ms20819-61 sleeve. Then flare.	MF. 07-01-09	<i>Z</i>	<i>Z</i> 07-01-15 QSI042	<i>Z</i> 07-01-08

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>4</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>AE</i>	APPROVED <i>JP</i>	DRAWING NO. D2003		
DATE 99.06.08		REV. B SHEET 1 OF 2		
		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS		
A	90.04.09	SCALE NEW ISSUE		
B	99.06.08	UPDATE PER TEMPLATES; ADD P/N'S; 0.025 TUBING NOW 0.035 (TSR1049)		

RELEASED

99.06.08 RE

NOTE: FLAT LENGTHS MAYBE
INCORRECT. BEND TO BENT
TOOL. REPORT TO ENGINEERING

UNDER REVIEW

CC.08.21 CB

some flat 06.12.13
lengths wrong

CB

SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. *29990*

P/N	TEMPLATE	HEATSLEEVE LENGTH ¹	CUT LENGTH OF TUBE ²	MRS20819-8J SLEEVE	AN818-8J NUT	MRS20819-8D SLEEVE	AN818-8D NUT	MRS20819-6D SLEEVE	AN818-6D NUT	DESC.	MATERIAL ^{4/8/7}	VENDOR OR SPEC	
D2003-001	T2003-001	5.2	6.00							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-003	T2003-003	7.3	8.12							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-005	T2003-005	9.8	10.62							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-007	T2003-007	20.0	19.63							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-009	T2003-009	12.38	12.44							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-011	T2003-011	33.31	32.38							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-013	T2003-013	12.7	13.54							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-015	T2003-015	17.2	18.00							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-017	T2003-017	17.0	16.25							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-019	T2003-019	9.8	10.62							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-021	T2003-021	N/A	2.25							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-023	T2003-023	4.5	5.33							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-025	T2003-025	9.8	10.60							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-027	T2003-027	7.25	7.38							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-029	T2003-029	17.2	18.00							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-700/6
D2003-031	T2003-031	14.6	15.38	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-033	T2003-033	29.75	29.62	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-035	T2003-035	24.7	27.00	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-037	T2003-037	24.81	23.38	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-039	T2003-039	34.0	34.00	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-041	T2003-041	6.0	5.88	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-043	T2003-043	11.7	10.75	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-045	T2003-045	3.50	2.44	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-047	T2003-047	5.56	5.56	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-049	T2003-049	33.2	34.00	2	2						TUBE ASS'Y	CRES 0.500 OD x 0.035 W	AISI 304
D2003-077	T2003-077	N/A	6.25							1 1	JET	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-101	T2003-101	13.25	13.13							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-103	T2003-103	12.38	12.00							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-105	T2003-105	10.75	10.60							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-107	T2003-107	12.75	12.25							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-600/6
D2003-109	T2003-109	8.25	8.125							2 2	TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-111	T2003-111	4.75	4.625								TUBE ASS'Y	6061-T6 0.500 OD x 0.035 W	WW-T-600/6
D2003-116	T2003-116	4.0									HEATSLEEVE	M2650-20 CRINKLE-SOFT	STRATOFLEX
D2003-120	T2003-120	4.0									HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-14	T2003-14	4.0									HEATSLEEVE	M2650-14 CRINKLE-SOFT	STRATOFLEX
D2003-16	T2003-16	4.0									HEATSLEEVE	M2650-16 CRINKLE-SOFT	STRATOFLEX
D2003-205	T2003-205	9.75	9.60							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6
D2003-207	T2003-207	3.75	3.75							2 2	TUBE ASS'Y	6061-T6 0.375 OD x 0.035 W	WW-T-700/6

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2003
DATE 99.06.08		TITLE 206 CABIN HEATER TUBE ASSEMBLIES NTS

REV. B
SHEET 2 OF 2**RELEASED**
99.06.08 RE**UNDER REVIEW**CB
06.12.13

~~06.08.21 CB~~
 Some flat length
 and wrong

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. ~~29990~~ 29990

Notes:

- (1) USE STRATOFLEX M2650-6 CRINKLE-SOFT HEATSLEEVE.
- (2) TUBING ASSEMBLIES TO BE CUT AND BENT IN ACCORDANCE WITH TEMPLATES.
- (3) TUBES TO BE FLARED 30° TO MATE WITH FITTINGS MADE TO MS33514.
- (4) ENSURE SEAMLESS TUBING IS USED.
- (5) INSTALL HEATSLEEVE OVER ALL TUBES WITH A DESIGNATED LENGTH OF HEATSLEEVE PER THE PARTS LIST.
- (6) 5052 (WW-T-700/4) TUBING MAY BE SUBSTITUTED WHEN 6061 TUBING IS NOT AVAILABLE.
- (7) 0.049 WALL THICKNESS CRES TUBING MAY BE SUBSTITUTED WHEN 0.035 IS NOT AVAILABLE.
- (8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

